Date

Wednesday, 6/27/2007 1:11:08 PM

User: Kim Johnston

Process Sheet



Customer

: CU-DAR001 Dart Helicopters Services

Drawing Name

Part Number

Due Date

NG

Job Number

: 33234

Estimate Number

: 10725

P.O. Number

Prsht Rev.

First Issue

Previous Run

:NA

This Issue

: 6/27/2007

S.O. No. : 1)

: NC

: 33215

Type : MACHINED PARTS

Written By Checked & Approved By

Comment

02.06.13 : Est Rev D

Now machined in house.

Drawing Number Project Number

Drawing Revision Material

: 7/20/2007

: BUSHING

: D2652

: NIA

: N/A

: A

· D2652 REV A

Qty:

200 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

10

M303R0500

303 Round Bar 0.500"



Comment: Qty.:

0.0578 f(s)/Unit Total:

11.5500 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

2.0

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK



Comment: SECOND CHECK



5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7/8/2 50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		·				7		

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>07/08/2</u> /
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification		Ammanal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Date:

Wednesday, 6/27/2007 1:11:08 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33234

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Le Drid8, 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP		PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					7				-
Part No	•	F	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date:	<u> </u>

QA: N/C Closed: ____ Date: ___

NCR:	İ	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annessal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto	
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33234
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
	Actual	Method

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	0.597	/			
0.060	+/-0.005	0.057	/			
Ø0.305	-0.002/+0.000	0.3o35	/			
Ø0.191	+0.005/-0.000	0.191	/			
Ø0.500	+/-0.010	0.496	V			
0.030 x 20°	+/-0.010	.03 X W°				
R0.010	+0.010/-0.000	.015	/			
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			*			
		4.		•		
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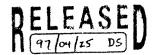
Measured by: カゴウ	Audited by:	Prototype Approval:	N/A
Date: 07/08/19	Date: 0708/19	Date:	

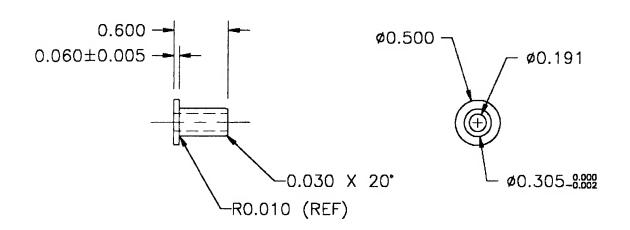
Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	- 4





DESIGN	DRAWN BY		ACE USA, INC.
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	BIBY	D2652	SHEET 1 OF 1
DATE		TITLE	SCALE
97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX SHOP COPY TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTED TO

ENGINEERING

NCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER 33234